

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013712**Date Inspected:** 05-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint WSD1-A801B/D-26 located on PCMK west tower, skirt assembly at the base.

Welder was identified as 201500. QC was identified as ZPMC CWI An Qing Xiang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shao Hai Long, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2112. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Li Shi You.

Bay 10

This QA Inspector randomly observed no apparent welding related work being performed in Bay 10.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

FCAW welding of weld joint SSD1-SA16F/G-48 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 057266. ZPMC QC was identified as CWI You Qi

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Guo (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

FCAW welding of weld joint SSD1-SA16F/G-46 located outside PCMK south tower, lift 1 base, skin E, shear plate stiffener to connection plate. Welder was identified as 057244. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding related operations was ABF Representative Zhao Ying Sheng.

ABF Representative Zhao Ying Sheng informed this QA Inspector that ZPMC personnel were performing fit-up of struts at the 53M, 65M, and 77M levels and no welding related work was being performed on any of the upper levels of the tower trial assembly. This QA Inspector climbed the stairs to the tower elevator access level, but after several attempts to call the elevator, received no response.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
